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NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY			
2	1	23350089	SPRING, COMPRESSION		X	X
3	1	23350091	SPRING, COMPRESSION			X
4	1	39000035	O-RING, (-015)	X	X	X
5	1	39051090	O-RING, (6.7mm x 1.8)	X	X	X
6	1	39051091	O-RING, (7.5mm x 1.5)	X	X	X
7	1	39051099	O-RING, (-030)	X	X	X
8	2	39051116	O-RING, (6.8mm X 1.9)	X		
9	1	39053048	WIPER, PRESS-IN, 16mm	X		
10	2	39055011	SEAL, BONDED, M3	X		
11	2	43068004	PLUG, SOCH, G1/8			
12	1	81000000	CONTACT BOLT, WS, 7MPa, 5.5 & 10kN			
13	1	91000040	BASE, WS, 7MPa, 10kN			
14	1	23350090	SPRING, COMPRESSION		X	
N/A	N/A	L6010001	KIT, SEAL, WS, 7MPa, CM/BM, 10kN	NOTED	N/A	N/A
N/A	N/A	L6110010	KIT, SPRING, WS, 7MPa, CM/BM, FA, 10kN	N/A	NOTED	N/A
N/A	N/A	L6110011	KIT, SPRING, WS, 7MPa, CM/BM, FA, 10kN	N/A	N/A	NOTED
N/A	N/A	ISL1007	INSTRUCTION SHEET, WS, 7MPa, CM/BM, FA, 10kN	N/A	N/A	N/A

See Instruction Sheet ISL1005 For Service Instructions.
 Lubricate All Seals With Clean Hydraulic Oil Prior To Assembly.
 Do Not Use Silicone Base Lubricants.

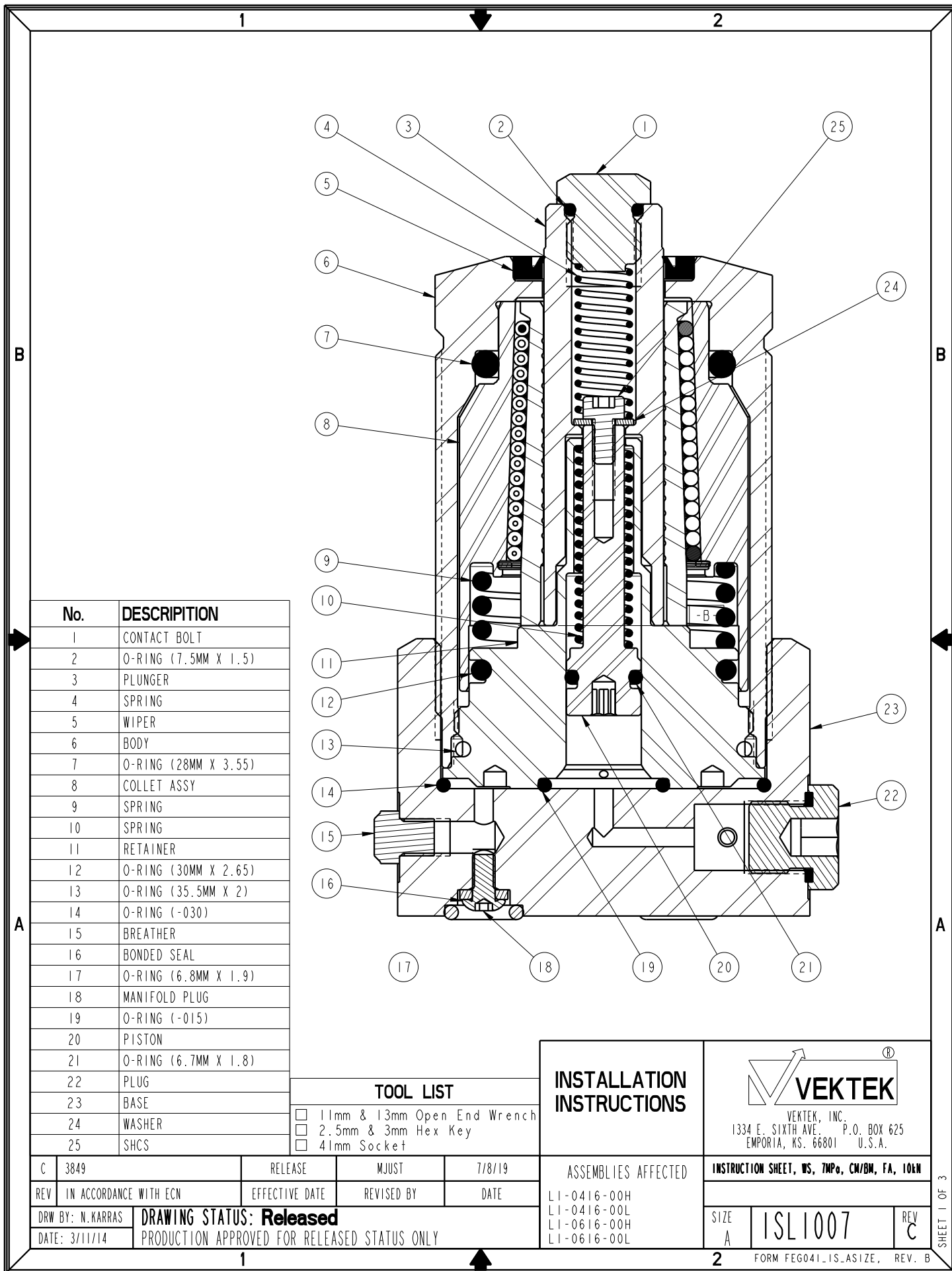
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2

C	3849	RELEASE	MJUST	7/2/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: N.KARRAS	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY			
DATE: 03/21/14				

PARTS LIST		
	VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
ASSEMBLIES AFFECTED L1-0616-00H L1-0616-00L	PARTS LIST, ASSY, WS, 7MPa, BM, FA, 10kN	
SIZE A	LPL1011	REV C

1
2

FORM FEG035_PL_ASIZE, REV. B



No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (7.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	BODY
7	O-RING (28MM X 3.55)
8	COLLET ASSY
9	SPRING
10	SPRING
11	RETAINER
12	O-RING (30MM X 2.65)
13	O-RING (35.5MM X 2)
14	O-RING (-030)
15	BREATHER
16	BONDED SEAL
17	O-RING (6.8MM X 1.9)
18	MANIFOLD PLUG
19	O-RING (-015)
20	PISTON
21	O-RING (6.7MM X 1.8)
22	PLUG
23	BASE
24	WASHER
25	SHCS

TOOL LIST

- ☐ 11mm & 13mm Open End Wrench
- ☐ 2.5mm & 3mm Hex Key
- ☐ 41mm Socket

INSTALLATION INSTRUCTIONS

ASSEMBLIES AFFECTED

LI-0416-00H
LI-0416-00L
LI-0616-00H
LI-0616-00L



VEKTEK, INC.
1334 E. SIXTH AVE. P.O. BOX 625
EMPORIA, KS. 66801 U.S.A.

INSTRUCTION SHEET, WS, 7MPo, CM/BM, FA, 101M

SIZE
A
ISLI007

REV
C

FORM FEG041-1S-ASIZE, REV. B

C	3849	RELEASE	MJUST	7/8/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: N.KARRAS	DRAWING STATUS: Released			
DATE: 3/11/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

SHEET 1 OF 3

B

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A

- A**

	
VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
INSTRUCTION SHEET, WS, 7MPa, CM/BM, FA, 10kN	
SIZE A	ISL1007
2	REV C

Assembly

Model Number L1-0416-00H & L1-0416-00L

1. Lubricate new O-rings (2),(14),(19),(21) and outside diameter of new wiper (5) with clean hydraulic oil (Vektek 65-0010-01 or equivalent). Also, apply light film of hydraulic oil to outside surface of plunger (3)
2. Press wiper (5) into top of body (6) taking extra care to install squarely without excess force. CAUTION: IMPROPER INSTALLATION COULD DAMAGE WIPER (5) CAUSING EXCESS WIPER DRAG.
3. Gently install plunger (3) into work support through wiper (5) taking care not to damage wiper (5). Plunger (3) should move freely without binding. Lightly push plunger (3) downward until bottoms.
4. Install O-ring (21) onto piston (20).
5. Slide return spring (10) onto piston (20) and insert piston (20) and return spring (10) into retainer (11) bore. Insert 3mm hex key into piston (20) and push inward to compress return spring (10). While holding piston (20) and return spring (10) in compressed position place washer (24) onto cap screw (25) and drop thread side down into hole through top of plunger (3). Insert 2.5mm hex key into cap screw (25) and torque to 2.5 N-m (20 in-lb). CAUTION: CONTACT SPRING (4) AND RETURN SPRING (10) ARE NOT INTERCHANGEABLE.
6. Insert contact spring (4) into hole through top of plunger (3). Contact spring (4) will pilot onto cap screw (25).
7. Install O-ring (2) onto contact bolt (1).
8. Screw contact bolt (1) into top of plunger (3). With 13mm wrench at plunger (3) and 11mm wrench at contact bolt (1) torque to 9 N-m (80 in-lb).
9. Install O-ring (19) into retainer (11) s'face.
10. Install O-ring (14) into bottom of fixture cavity.
11. Using 41mm socket, screw work support into fixture cavity. Torque to 55 N-m (40 ft-lb).

Model Number L1-0616-00H & L1-0616-00L

12. Complete assembly steps 1-9.
13. Install O-ring (14) into bottom of base (23) cavity.
14. Using 41mm socket, screw work support into base (23) cavity. Torque to 55 N-m (30 ft-lb).
15. If work support hydraulics or vent is manifold fed from fixture, install new O-ring (17) into manifold s'face on base (23) mounting face (2 places).
16. If work support hydraulics or vent is not manifold fed, install bonded seal (16) onto plug (18), insert 3mm hex key into plug (18) and torque to 3 N-m (25 in-lb) (2 places).

	
VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
INSTRUCTION SHEET, WS, 7MPo, CW/BM, FA, 106N	
SIZE A	ISL1007
REV C	

FORM FEG041-1S-ASIZE, REV. B

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